

# Work Order ID 68136

Thursday, April 07, 2011 7:41:00 AM



Page 1

Item ID: D2620

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube, 206 Skidtube

Start Date: 4/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2620	Rev B

100 Skidtubes 0.00



Skidtubes

Memo

0.00

Skidtubes

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A □ and Folio Ft008□2- Cut Fwd end of tube as per Dwg D2620

Folio -15

*DP/SAD*

11-4-29

110 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

*B 11.5.05 107*

120 Identify as per dwg & Stock Location: 46 0.00



Packaging

Memo

0.00

Packaging

*B 11.5.05 107*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68136**

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Thursday, April 07, 2011 7:41:00 AM

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Stop



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Start Date: 4/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/648

11-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 07, 2011 7:40:57 AM

Page 1

Work Order ID: 68136



Parent Item: D2620



Parent Item Name: Skidtube, 206 Skidtube


Start Date: 4/7/2011

Required Date: 4/12/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP D02.07.26 Change Dwg to rev.B; Updated Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-160  Extrusion Round 3" 206		Manufactured	No			100	Each	46.0000	1	10			

Location

LG

43969

59875

Loc Qty

46

19

27

Loc Code

10 AD 11-4-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

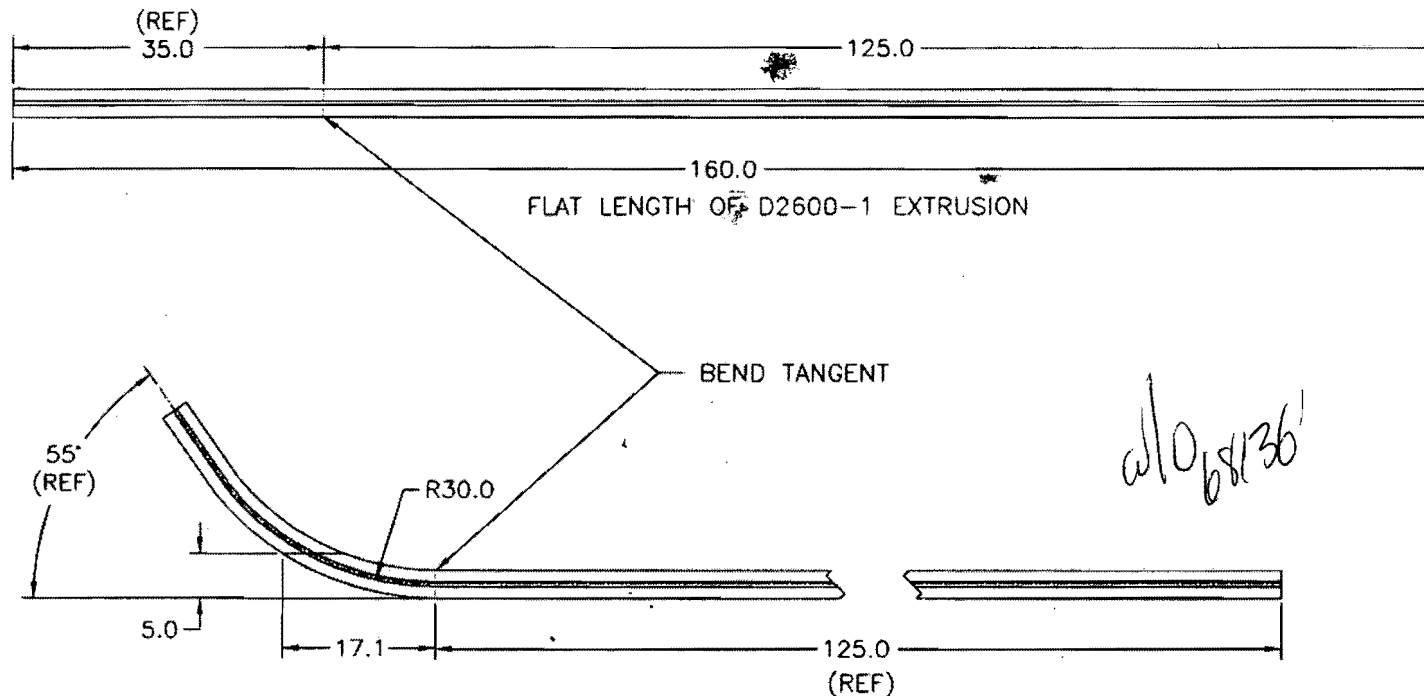
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# SPECIFICATION CONTROL DRAWING

## 206 SKIDTUBE BENDING



### DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.  
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.  
DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE  $3.20 \pm 0.200$  IN THE BEND.  
TUBE WIDTH SHOULD BE  $3.200 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE  $3.15 \pm 0.200$  IN THE BEND.  
TUBE HEIGHT SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

**DART**



DESIGN	DRAWN BY	TITLE
CHECKED	APPROVED	DRAWING NO.
DATE	DATE	206 SKIDTUBE BENDING CONTROL
99.09.10	97.11.07	NEW ISSUE
A	97.09.10	UPDATE FOR IN-HOUSE BENDING
B		

DART AEROSPACE USA, INC.  
FAIRCHILD INTERNATIONAL AIRPORT, WA

REV. 8  
SHEET 1 OF 1  
SCALE 1:20

**RELEASED**  
44 04/15 DS